



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-702-307
Job Sheet 179204



Part No: D412-702-307

Job Qty: 1 ea

Part Name: Harness Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: ICAD412-702 REV 6 SHEET 49 IPP Rev:A new issue DD 10.04.30 verified:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/15/18	6/15/18	0.00	0.00	Start Up Small Fab-3	1-88	JUN 15 2018
100	Small Fab	1 pcs	6/15/18	6/15/18	0.00	0.19	Small Fab-6	1-88	38
110	QC	1 pcs	6/15/18	6/15/18	0.00	0.00	QC5	1-88	JUN 20 2018
120	Packaging	1 pcs	6/15/18	6/15/18	0.00	0.00	Packaging3-2	1-88	JUN 27 2018
130	QC21-FG	1 Ea	6/15/18	6/15/18	0.00	0.00	QC21	1-88	21

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3573-3	Adapter	1 Ea (1 ea)	90-Start up Operation	1084085
D4088-041	Shoulder Harness	1 Ea (1 ea)	90-Start up Operation	1055591
MS21042L3	Nut	4 Ea (4 ea)	90-Start up Operation	1078167
MS24693-S272	Screw	4 Ea (4 ea)	90-Start up Operation	1044219
NAS1149D0316J	Washer	4 Ea (4 ea)	90-Start up Operation	1014102-2

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3573-3	1	1	0
	D4088-041	1	12	0
	MS21042L3	4	1,637	0
	MS24693-S272	4	141	0
	NAS1149D0316J	4	689	0

Part Specifications

Specifications could not be found.

Plex 6/14/18 1:06 PM Dart.lajeunesse.marie

3905

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		AGAINST DEPARTMENT/PROCESS		Water Jet		Engineering	
Part No. _____		Rework		Prod. Eng. Coord.		Quality	
NCR No. _____		Use-as-is		Rec/Store/Packaging		Other	
Date: _____		Suspected Unapproved		Supplier		MRB (QS1042) Approval	
Step #: _____		QTY Effective: _____		Cross tube			
Description Work Order Deviation		Dispositi		Small Fab			
				Finishing			
				Composite			

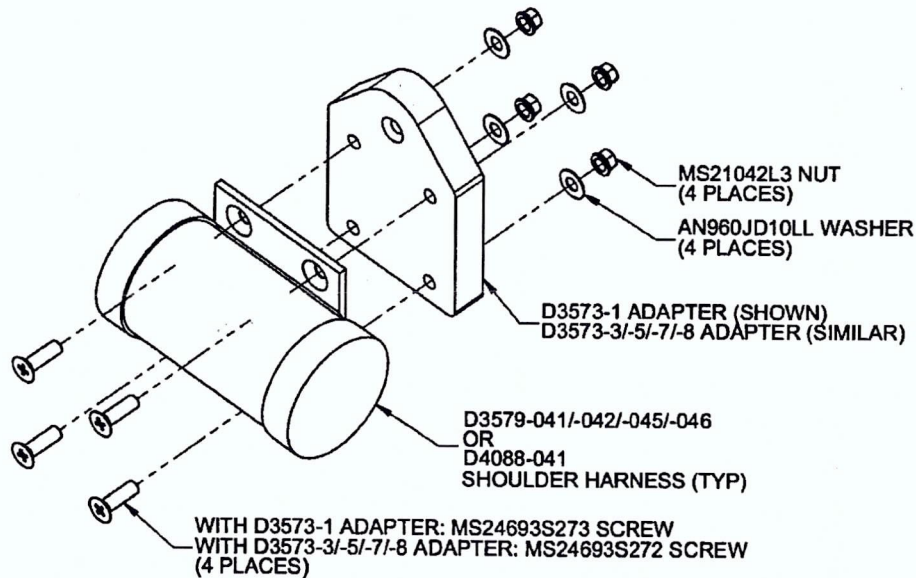
Container No: S084773
 Part: D412-702-307
 Job No: 179204
 Serial No/Batch: S084773
 Revision: 6
 Inspector:
 Exp Date:
 Instructions:

Date: 06/27/18

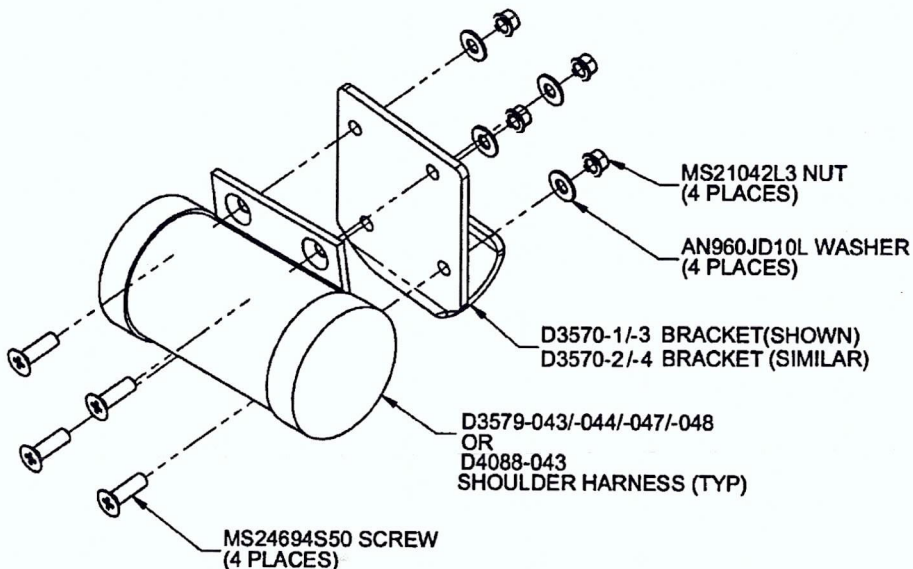
Completed By _____
 hand / Supervisor
 proval Verification

QC / QA Coordinator
 Approval

Root Cause		FAULT CA	
Environment	No Re-verification	Temperature/Cure	Positioned Wrong
Design	Operator	Set-up	Outside Dimensions
Doc/Data	Offset/Setup	BOM/Route	Over/Under tolerance
Equip/Tooling	Supplier	Broken/Damage/Defect	Part Incorrect
Handling/Pre	Training	Inspection Incomplete/Unqualified	Part Lost/Missing
Material	Use for Testing	Contamination	Part Moved
Internal Transport	Poor Information	Countersink	Drawing
Tribal Knowledge	Rushing	Cut Too Short	Finish
LOA	Product Improvement	Instructions Incomplete/Unclear	Misread
Substation	Process Improvement	Drill Holes	Turning Sequence
Past Expiry Date	Manufacturing Process		
Misidentified	Past Due		
OTHER: _____			



**DETAIL 'K' D412-702-101A/-103A/-105A/-107A/-109A/-115A/-117A AND
D412-702-101B/-103B/-105B/-107B/-109B/-115B/-117B OR -301/-303/-305/-
307/-309/-315/-317 HARNESS ASSEMBLIES**



DETAIL 'L' D412-702-111A/-111B/-113A/-113B OR -311/-313/-321/-323 HARNESS ASSEMBLIES

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25-00-00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3201-3

Job Sheet 179207



Part No: D3201-3

Job Qty: 4 ea

Part Name: Angle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 6/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev: A Removed from 9 Digit 06-01-25 JLM IPP Rev: B Now on Waterjet 06-08-14 JLM IPP Rev C added scribing NCR262 07.11.29 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	6/28/18	6/28/18	0.00	0.00	Start Up Waterjet		SP 18/06/19
100	Waterjet	4 pcs	6/28/18	6/28/18	0.00	0.06	Waterjet1		SC 18/06/19
120	QC	4 pcs	6/28/18	6/28/18	0.00	0.00	QC8		38
140	Brake NC	4 pcs	6/28/18	6/28/18	0.05	0.09	Brake NC 1		DAS SP
150	QC	4 pcs	6/28/18	6/28/18	0.00	0.00	QC5		38
160	HandFinish	4 pcs	6/28/18	6/28/18	0.00	0.10	HandFinish1		BEB 18-06-27
170	QC	4 pcs	6/28/18	6/28/18	0.00	0.00	QC7-2		38
180	Packaging	4 pcs	6/28/18	6/28/18	0.00	0.00	Packaging3-1		JUN 27 2018
190	QC21-SA	4 Ea	6/28/18	6/28/18	0.00	0.00	QC21		21 JUN 27 2018

Part Op 100 - 1-Cut as per Dwg D3201 (CHECK GRAIN DIRECTION BEFORE CUTTING) (CHECK GRAIN DIRECTION BEFORE PASSING IN DEBBURING MACHINE)
140 - 1-Bend as per Dwg D3201

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	.1800 sf (.045 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.050	0	83	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	3.760inches ± 0.030	3.790 3.730	3.753	
2	Doubler	3.460inches ± 0.030	3.490 3.430	3.456	
3	Doubler	1.680inches ± 0.030	1.710 1.650	1.678	
4	Doubler	0.050inches ± 0.010	0.060 0.040	0.050	

H:/FORMS/Quality Assurance/approved QA/NCRWO Rev I